



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D5018-1
Job Sheet R201487



Part No: D5018-1

Job Qty: 4 pcs

Part Name: Support, 214 Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/19

Job Tracking No: ECN19-829

Due Date: 10/14/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG D5018 REV B IPP REV. A NEW ISSUE JFS 14/01/20 VERIFY BY: JLM/IPP Rev.B 19.10.01 DWG revision (ECN 19-829) DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Rework - 1 - Startup	4 pcs	10/14/19		2.00	3.33	HAAS - 1		JL 19-11-05
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	4 pcs	10/14/19		0.00	0.00	QC 2 - 1		JL 19-11-05
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



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CANADA
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Container No: S229644



Part: D5018-1

Job No: R201487

Serial No/Batch: S229644

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/06/19

Plex 10/4/19 11:59

120 QC 8	4 pcs	10/14/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Crosstubes - 2 - B4B	4 pcs	10/14/19	0.00 0.23	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
140 QC 3	4 pcs	10/14/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	

19/11/17 23:09
DAS

NOV 08 2019
DAS

NOV 08 2019
DAS

150 Packaging 3-1 - Stock - B4B 4 pcs	10/14/19	0.00 0.00	QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	DAS
			Packaging 3 - 22 - B4B	41 NOV 16 2019
			Packaging 3 - 23 - B4B	3-89
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
160 QC 21 - SA 4 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21 NOV 18 2019
			QC 21 - SA - 53	3-89

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FB249 FOLIO REV: A1 DWG REV: B 2-

Descriptions: Deburr

130 - (Crosstubes) Per note 9 on page 1 of dwg D5018, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. A/R SCOTCH-WELD BATCH: 5206999 exp 8/21

140 - QC3- Inspect Part Finish

150 - Identify as per dwg & Stock Location: L6053 LOCATION : L6053

160 - QC21- Final Inspection - Work Order Release

Job BOM

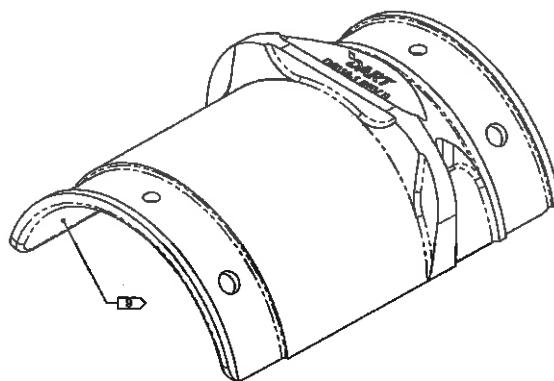
Part / Item	Component Name	Quantity	Operation	Container
D5018-1	Support, 214 Aft	4 pcs (1 ea)	100-Rework - 1 - Startup	F130699(2) S104905(2)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Rework - 1 - Startup	D5018-1	4	4	0

Part Specifications
Specifications could not be found.

Plex 10/4/19 11:59 AM dart.lacelle.linda



D5018-1 SUPPORT, 214 AFT

RELEASED
2019-09-30
TSCA 15-0004

NOTES:

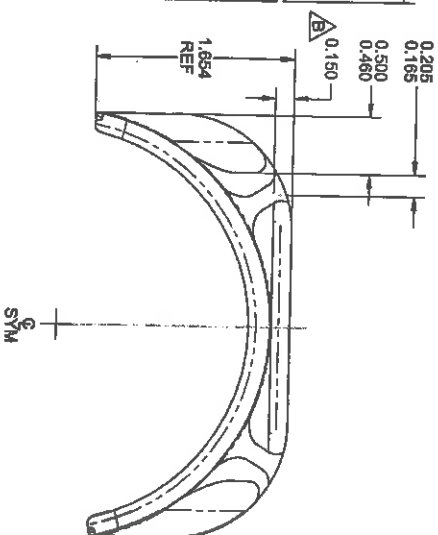
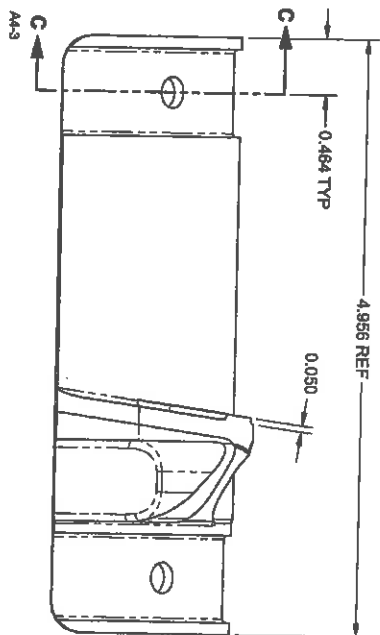
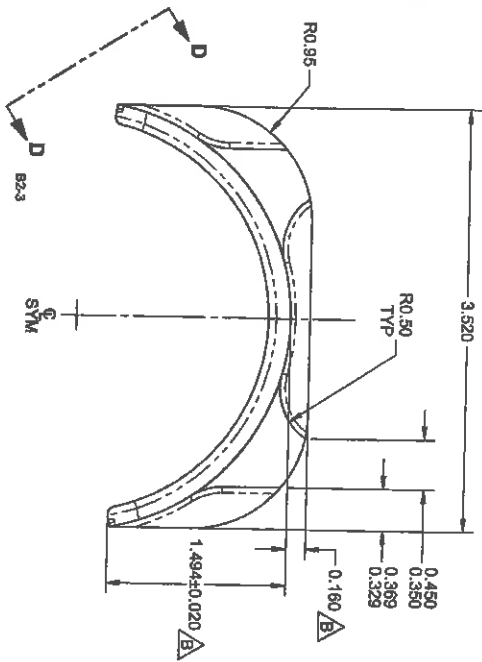
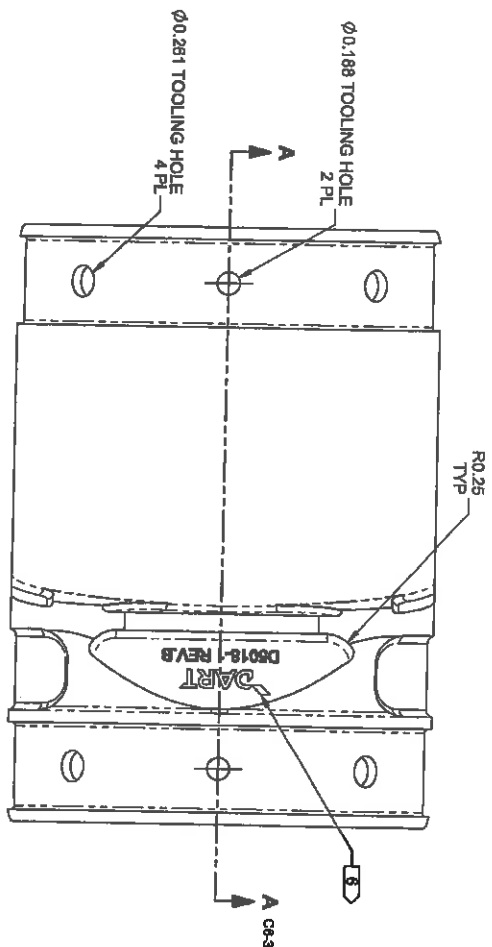
- 1) MATERIAL: MAKE FROM D5018-TTRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO, PART NUMBER, AND REVISION IN THIS AREA WITH 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3
- 7) WEIGHT: 1.07 lbs
- 8) MACHINE INNER SURFACE PROFILE AND NON-DIMENSIONS FEATURES PER D5018-1-REV.B STEP
- 9) FOR ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER, REMOVE RESIDUE WITH MEK (OR EQUIV.), APPLY 0.005" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

0	CHG INNER SURFACE PROFILE, 3M 2216 NOW 0.030 THICK, RAY SECTION B-B, RE-DIM FOR EASE OF MFR	CP	19.07.12
A	NEW ISSUE	CP	13.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	CP		
CHECKED	MW		
MFG. APPL	NO		
APPROVED	NO		
DE APPR	CP		
DATE	19.07.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5018** REV. B
TITLE **SUPPORT, 214 AFT** SHEET 1 OF 4
SCALE NTR

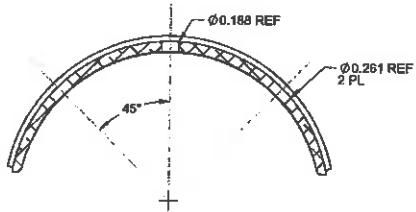
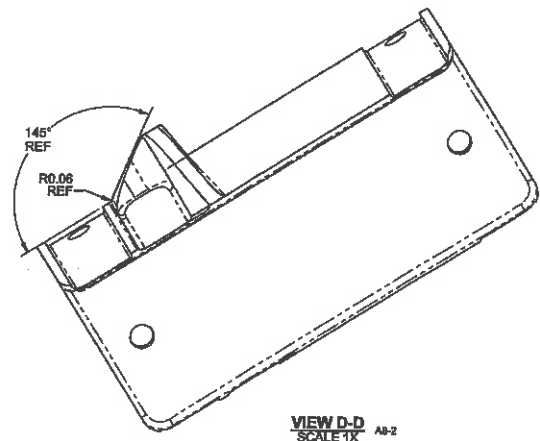
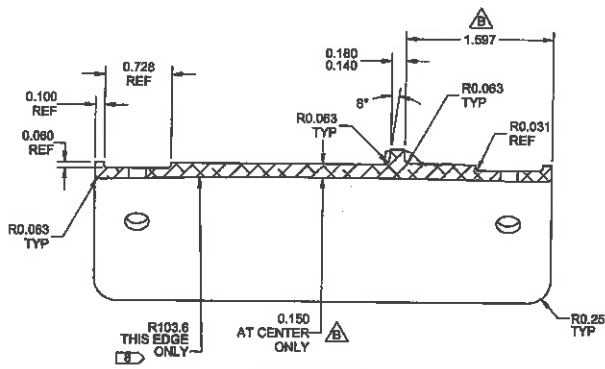
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APPROVED

DESIGN	CP	DART AEROSPACE LTD
DRAWN	CP	HAMILTON, ONTARIO, CANADA
CHECKED	MM	
MFG. APPR.	RQ	D5018
APPROVED	NO	
DATE	CP	SUPPLY, 214 AFT
19.07.12		
		SCALE
		NTS

RELEASED
2019-09-30



RELEASED
2019-09-30

DESIGN		CP	DART AEROSPACE LTD	
DRAWN		CP	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		MY	DRAWING NO.	REV. B
MFG. APPR.		RQ	D5018	SHEET 3 OF 4
APPROVED		NO	TITLE	SCALE
DE APPR.		CP	SUPPORT, 214 AFT	NTS
DATE		19.07.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	

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